






Work Order ID 52589

October 2, 2009 11:22:45 AM





Page 1

Item ID: D3535-25 Accept  Setup Start 
 Revision ID: B Stop 
 Item Name: Wearshoe
 Start Date: 02/10/2009 Start Qty: 10.00  Cust Item ID:
 Required Date: 20/10/2009 Req'd Qty: 10.00  Customer:


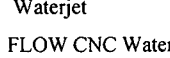
Reference:

Approvals: Process Plan: RP Date: 09-10-2 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____



Run Start 
 Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3535	Rev B

100  FLOW WATER JET 0.00
 Waterjet  Memo 0.00
 FLOW CNC Waterjet 1-Cut as per Dwg D3535 ☐ Dwg Rev: B ☐ Prog Rev: B ☐ 2-
 Deburr if necessary

B 9-10-19

110  QC2- Inspect parts off machine FAI/FAIB 0.00
 QC  Memo 0.00
 Quality Control

B 9-10-19

120  QC8- Inspect parts - second check 0.00
 QC  Memo 0.00
 Quality Control

B 9-10-19

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Page 3

Item ID:	D3535-25	Accept		Setup	Start	
Revision ID:	B				Stop	
Item Name:	Wearshoe					
Start Date:	02/10/2009	Start Qty:	10.00		Cust Item ID:	
Required Date:	20/10/2009	Req'd Qty:	10.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160	QC3- Inspect Part Finish	0.00							
QC	Memo	0.00							
Quality Control									

Umo 09/10/26

x10

170	Identify as per dwg & Stock Location:	0.00							
Packaging	Memo	0.00							
Packaging									

HL 09/10/26

(x10)

Ø

180	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

2310-28

RL 09-10-24

Picklist Print

Page 1

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Work Order ID: 52589



Parent Item: D3535-25RevB



Parent Item Name: Wearshoe



Start Date: 02/10/2009

Required Date: 20/10/2009

Comments:

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S20GA 		Purchased	No			100	sf	193.2306	5.3684			
304/316 .040 Sheet												VB9410-19

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	193.2306474	
110076	31.73	
111571	12.1938474	
112567	149.3068	

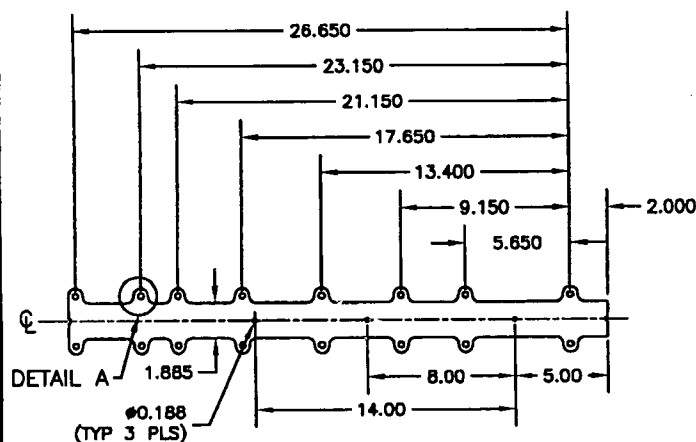
112567

DART

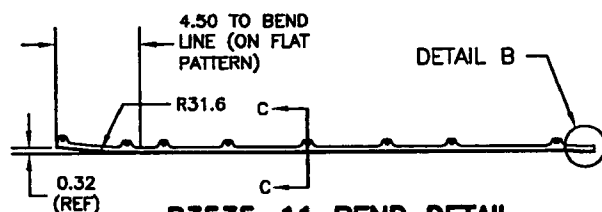
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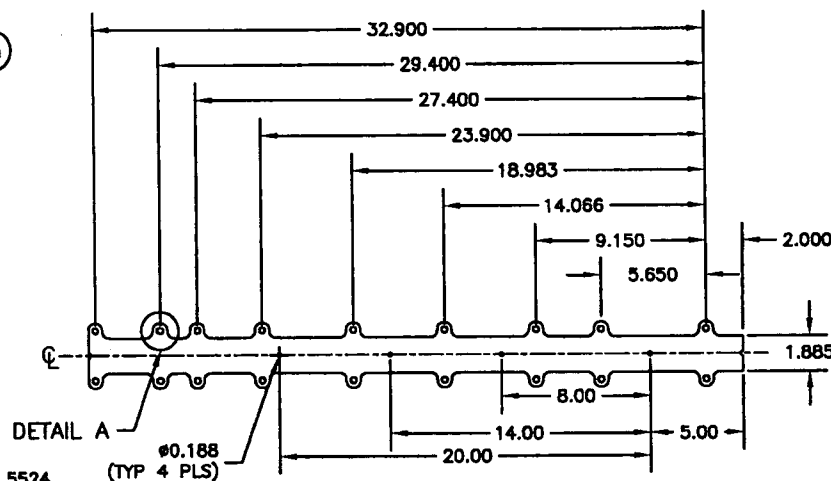
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ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 52589
BT 09-10-2



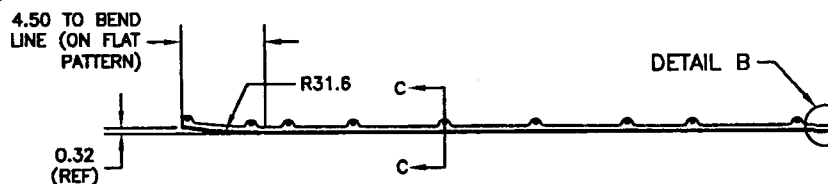
D3535-11F FLAT PATTERN



D3535-11 BEND DETAIL



D3535-13F FLAT PATTERN



D3535-13 BEND DETAIL

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT \bar{C}
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	REV. B
CB	PH	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 7
PH	PH	D3535	
DATE	TITLE	SCALE	
07.04.17	WEARSHOE	1:10	
A	06.10.25	NEW ISSUE	
B	07.04.17	MOVE TAB OUTBOARD, ADD AMS SPEC	

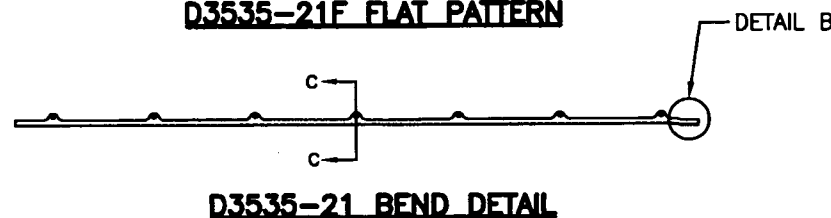
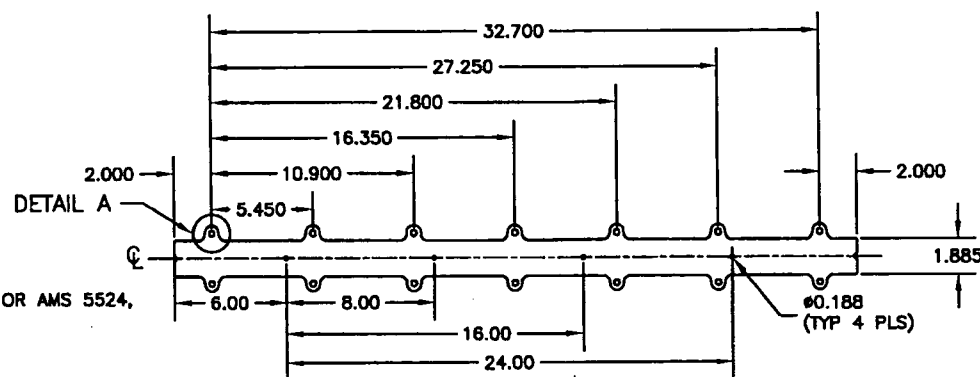
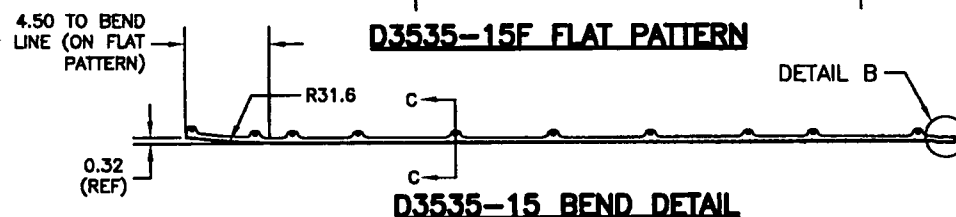
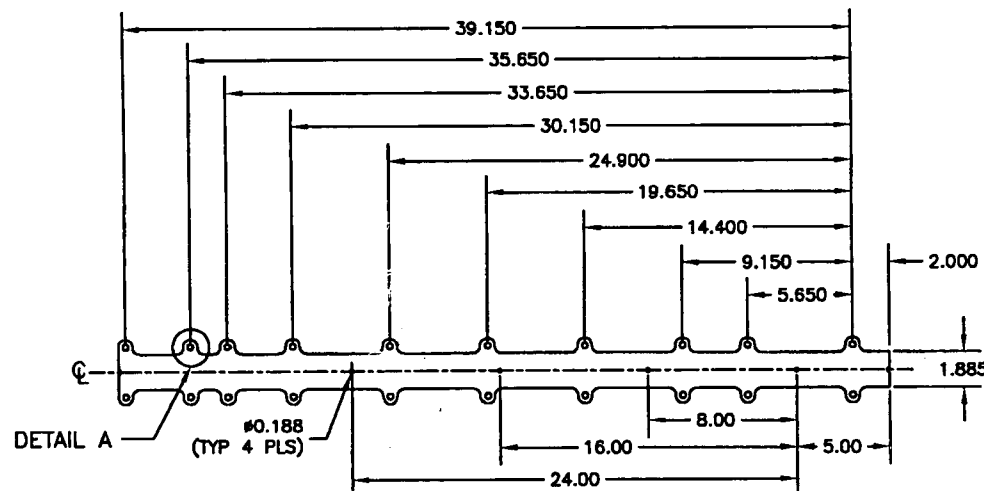
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				REV. B
				SHEET 2 OF 7



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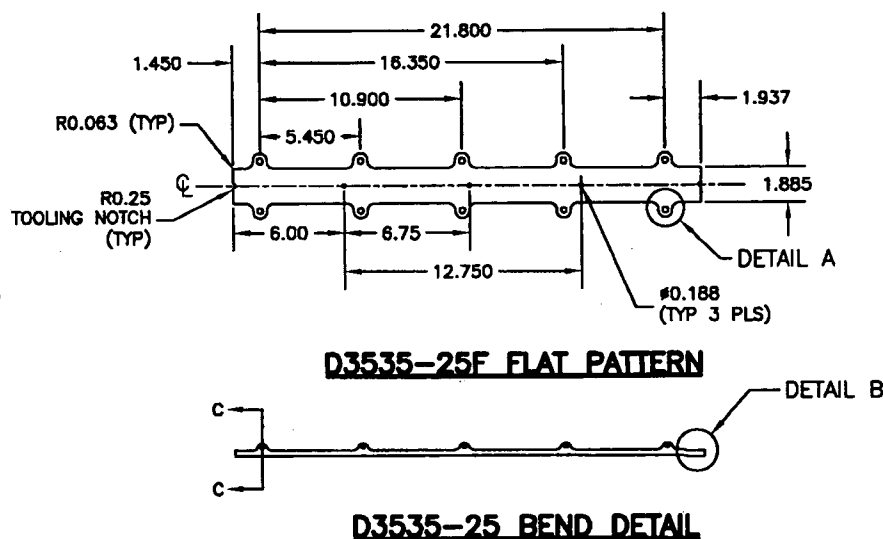
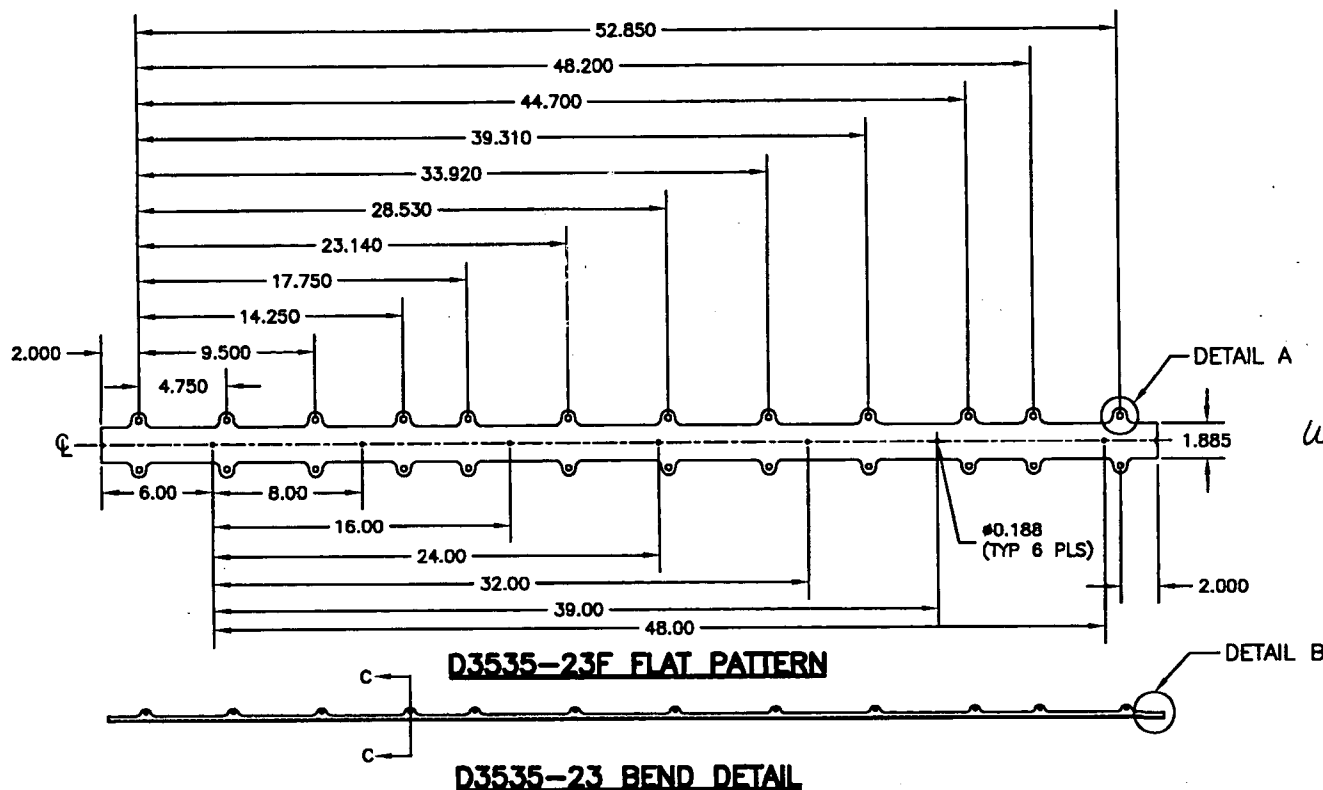
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		SHEET 3 OF 7		
		SCALE		
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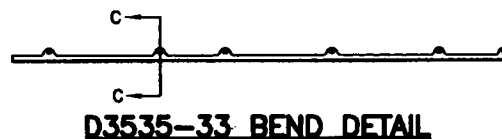
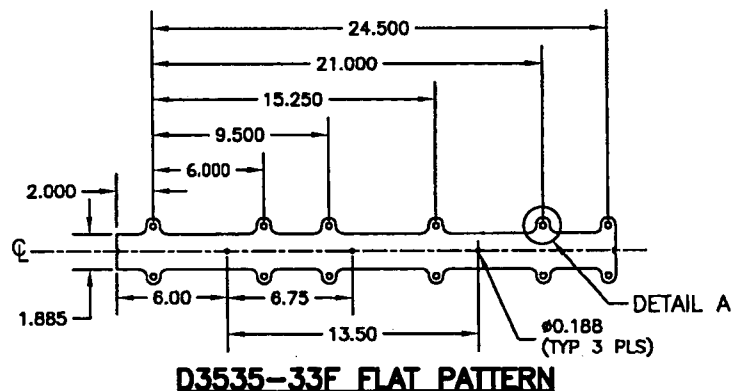
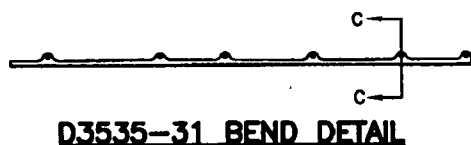
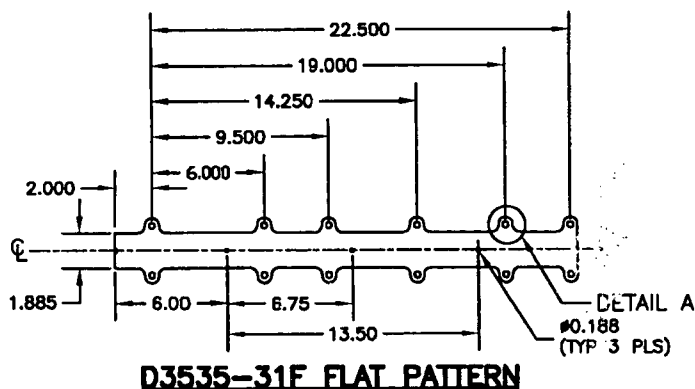
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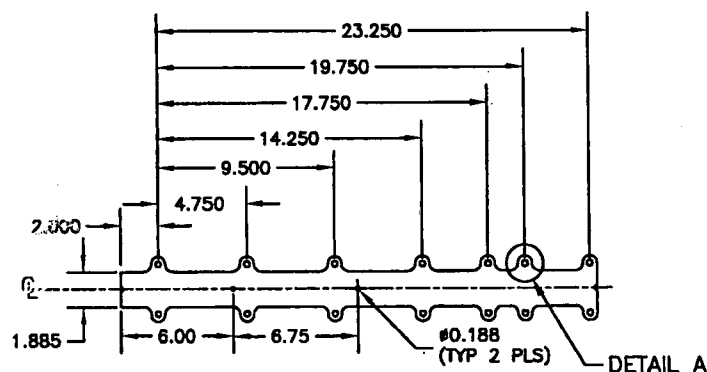
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			WEARSHOE	SHEET 4 OF 7
				SCALE 1:10

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DATE	07.04.17	DRAWING NO.	D3535	WEARSHOE	SHEET 5 OF 7
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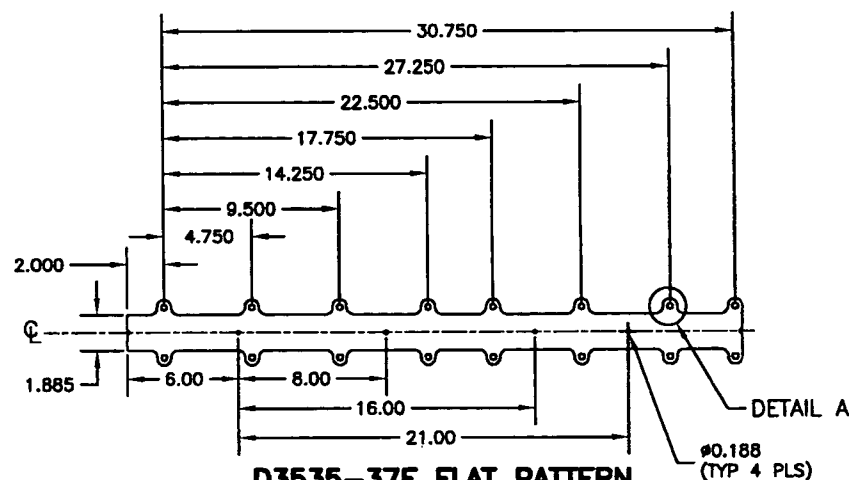


D3535-35F FLAT PATTERN



D3535-35 BEND DETAIL

w/o 52589



D3535-37F FLAT PATTERN



D3535-37 BEND DETAIL

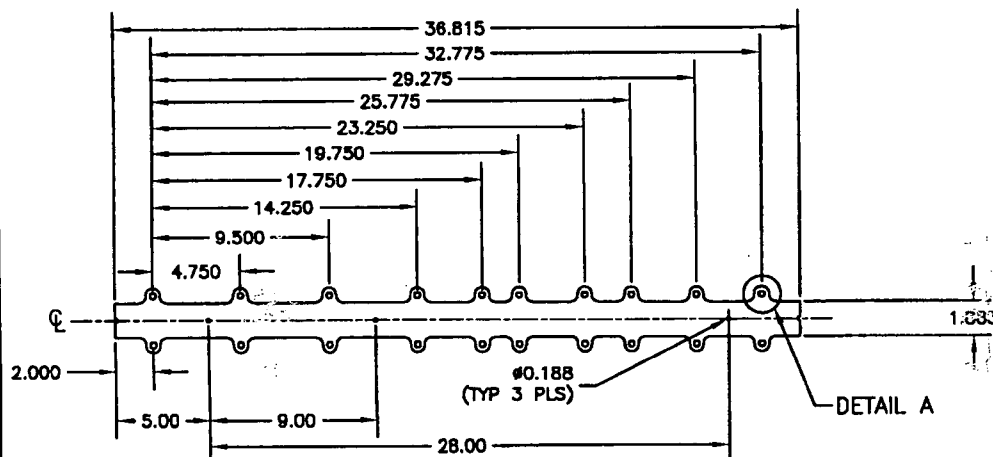
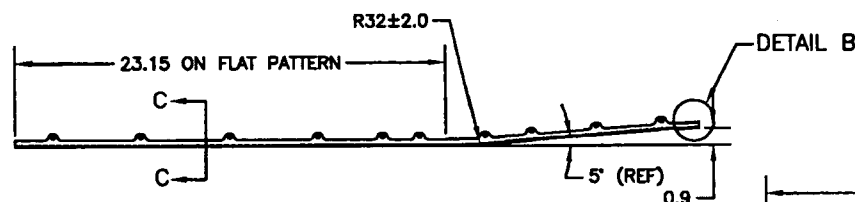
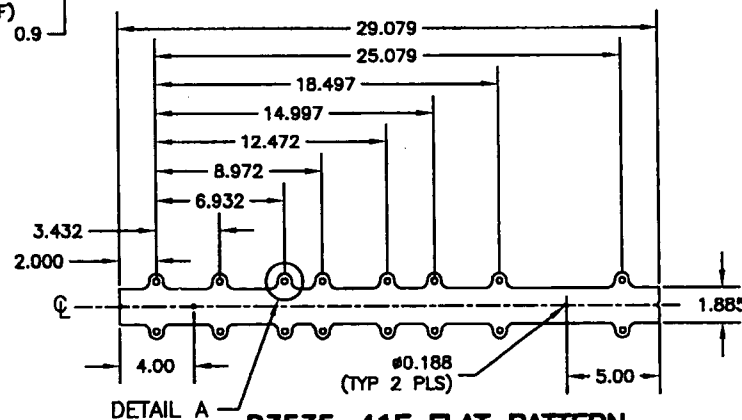
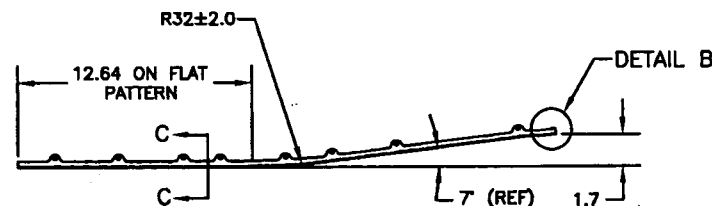
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**D3535-39F FLAT PATTERN****D3535-39 BEND DETAIL****D3535-41F FLAT PATTERN****D3535-41 BEND DETAIL****NOTES**

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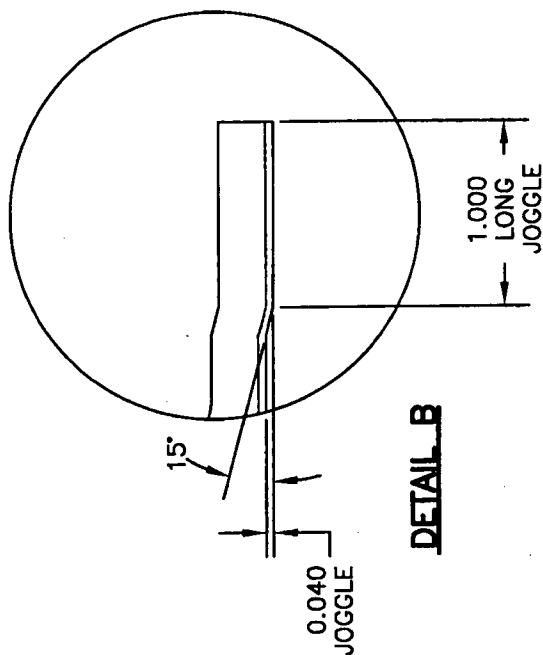
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			WEARSHOE	SHEET 6 OF 7
				SCALE 1:10



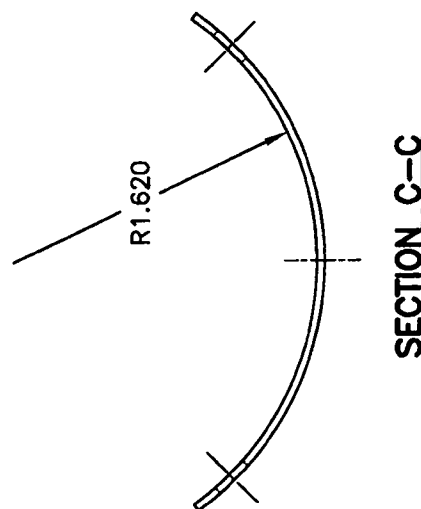
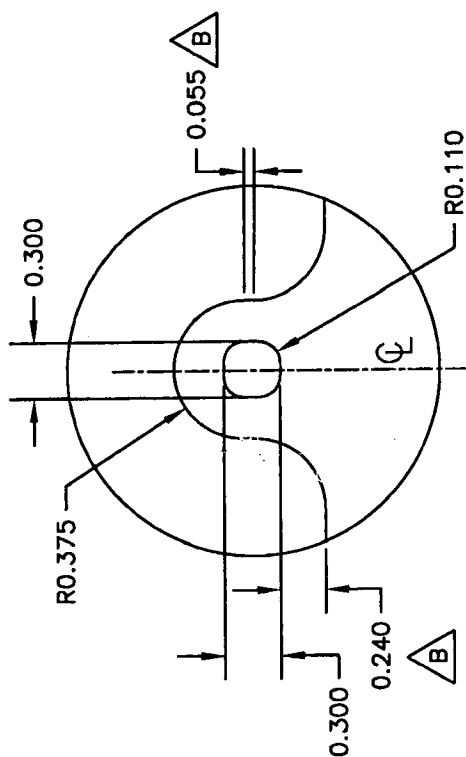
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DATE 07.04.17	TITLE WEARSHOE SCALE 1:1		

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